



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3027-7
Job Sheet 178556



Part No: D3027-7

Job Qty: 12 ea

Part Name: Clip



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: ~~6/26/18~~ July 5

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.07 Added forming step and Issue P/O KJ/JLM IPP Rev:B Now on WaterJet 08-12-08
JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	6/26/18	6/26/18	0.00	0.00	Start Up Waterjet		SL 18/06/11
100	Waterjet	12 pcs	6/26/18	6/26/18	0.00	0.32	Waterjet1		SL 18/06/11
120	QC	12 pcs	6/26/18	6/26/18	0.00	0.00	QC8		38
130	Brake NC	12 pcs	6/26/18	6/26/18	0.01	0.28	Brake NC 1		DAS 38
140	QC	12 pcs	6/26/18	6/26/18	0.00	0.00	QC5		38
150	HandFinish	12 pcs	6/26/18	6/26/18	0.00	0.28	HandFinish1		38
160	QC	12 pcs	6/26/18	6/26/18	0.00	0.00	QC7-1		38
170	Packaging	12 pcs	6/26/18	6/26/18	0.00	0.00	Packaging3-1	STOIS	JUL 05 2018
180	QC21-SA	12 Ea	6/26/18	6/26/18	0.00	0.00	QC21		JUL 05 2018

Part Op 100 - 1-Cut as per Dwg D3027 ***NOTE GRAIN DIRECTION*****
Descriptions: 130 - Deburr if necessary Form as per Dwg D3027

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2880 sf (.024 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	0	83	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clip	1.850inches $\pm$ 0.010	1.860 1.840	1,848	
2	Clip	1.870inches $\pm$ 0.010	1.880 1.860	1,874	
3	Clip	0.130inches $\pm$ 0.030	0.160 0.100	0,130	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐		Cross tube ☐ Water Jet ☐		Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____		 Container No: S080026 Part: D3027-7 Job No: 178556 Serial No/Batch: S080026 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/11/18		1042) Approval _____		Deleted By _____	
Description Work Order Deviation						Unit / Supervisor Verification _____		Coordinator Approval _____	
Root Cause									
Environment	☐	No Re-verification	☐	Pressure/Force	☐	Tool Wear, Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐		☐				
Misidentified	☐	Past Due	☐	OTHER :					